

Date:

Tuesday, 7/17/2007 1:57:59 PM

User:

Kim Johnston

Process Sheet

35

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACCESS STEP RH HEAVY DUTY
 Job Number : 33575
 Estimate Number : 12947
 P.O. Number : N/A
 This Issue : 7/17/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : N/A
 Written By :
 Checked & Approved By : 07.07.17
 Comment : Est Rev: Now in Coss 07-07-17 JLM Verified By: EC

Part Number : D412630012
 Drawing Number : D2812 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 8/30/2007

ASSEMBLE PER HAND CHARGES 107.007

Qty: 7 Um: Each

No LATER!

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-630-012

CHG 005

2.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Extrusion

Batch: 332858

a.m

07.08-09

⑦

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Extrusion as per D2812.

a.m 07.08-09

⑦

2-Bevel End and Deburr.

1E 07.08.09

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/10

⑦

5.0

D2795042

Arm RH



Comment: Qty.: 3.0000 Each(s)/Unit Total : 21.0000 Each(s)

Arm LH

Batch: 333582





1E 07.08.10

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/30	309	Brushing D2E 52 Too Long	 07-08-30	have too removed .50" shorter to compensate for extra paint thickness	MF. 07-08- 30	 07/08/31	 07-08-30	 07/08/31

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 1:57:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D2875

End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

End Plate

Batch: 311351

07-08-10

7

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and (1)end cap as per Dwg D2812& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

M103794
M104721

2-Grind end cap welds flush as per Dwg D2812

07-08-14

7

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/14 (7)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/14 (V7)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-08-14

(7)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld End Cap per Dwg D2812

A/R AL ROD

Batch: M103794

07-08-15

7

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/15 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/15 57RH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/15

7X

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Green Sander
M-105068

M-102316

07/08/15

7X

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2812 and QSI 005 4.4

Batch: M-104972 M-105386

BR/M-L

07-08-16

07/08/28

7

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07-08-28

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

19.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Clevis

Batch: 32551

50

20.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer


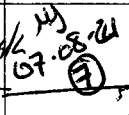
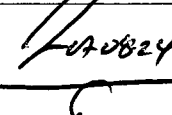
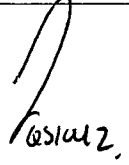
Batch: 130543

1/8/20 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/09/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/20	#15.0	wrong powder coat color was written on the ZPP/40		Remove powder coat and wing walk Remove wing walk - sand white with 320 grit paper - Red 314/121 Re powder coat green sand AS per QSI 0054.3	 07/08/20	 07/08/20		EP 07/08/20

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D2652

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Bushing

Batch: 33215 SQ

22.0

D2803042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bracket Assembly

Batch: B-33589 JB

23.0

D2804042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bracket Assembly

Batch: B34018 5 39 277 1X

24.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Support Prop

Batch: B29822 SQ

25.0

D28103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Strut

Batch: B33591 SB

26.0

D2813

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Batch: B29396 25923 33592 2 SP

27.0

D2990042

Bracket Assembly RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bracket Assembly LH

Batch: B29396 B33591 7/8/20 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s)

Bolt

Batch: M15432 SP

29.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Bolt

Batch: M101291 M103962 SP

30.0

AN816

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 21.0000 Each(s)

Bolt

Batch: M101884 M103138 SP

31.0

AN3108

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 21.0000 Each(s)

Nut

Batch: M101884 M19633 SP

32.0

MS24665285

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total: 21.0000 Each(s)

Cotter Pins

Batch: M2424 M9003 SP

33.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer

Batch: M104885 SP

34.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Washer

Batch: M104215 7/8/20 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 1:57:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 6.0000 Each(s)/Unit Total : 42.0000 Each(s)
1/2" washer, Alum
Batch: 6956 SP

36.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)
Nut
Batch: M104936 SP

37.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)
Nut
Batch: M102552 SP

38.0

MS24693S280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)
Screw
Batch: M100622 7/8/20 SP

39.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Inn D412-630

mf 07-08-31

40.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

700831 (7)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

P70

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/08/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
2150								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
21/08/30	390	Due to re-powder casting, the D2990-042 bracket fits really tight on the center mm. P.C: Too much product, with arm of bracket combined.	QS1042	Remove lay sanding down to the base aluminum, all the green powder coat, using a 320 to finish, ensure a smooth blend. Touch-up Areas with plodine per QS1045. Powder coat the center arm green per QS1045.	PK 21/08/31	21/08/31	QS1042	21/08/30

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Clevis

Batch: B 32551

SP

43.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Spacer

Batch: B 30543

SP

44.0

D28061

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Bushing

Batch: B 29393

32773

SP

45.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bushing

Batch: B 29847

SP

46.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bolt

Batch: M101291

SP

47.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Bolt

Batch: M104072

SP

48.0

AN515A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Batch: M104547

3/8/20 SE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH HEAVY DUTY

Job Number: 33575

Part Number: D412630012

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M104215

54

50.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Batch: M104156

50

51.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 35.0000 Each(s)

Nut

Batch: M102552

150

52.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Batch: M104118

2/8/20 50

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-012

Location: B

PPP Rev: B

Per 7/18/31 (7)

55.0

QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

7/18/31

Job Completion



7/18/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

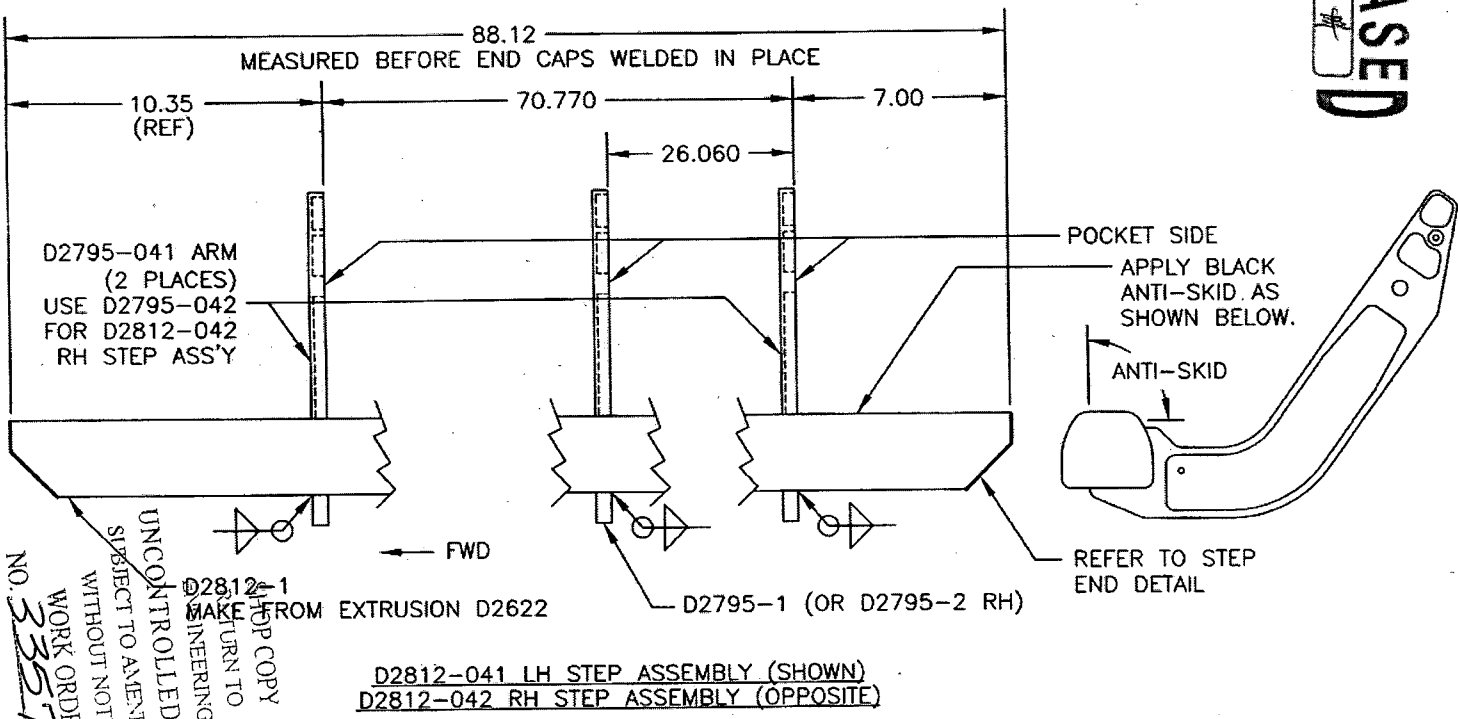
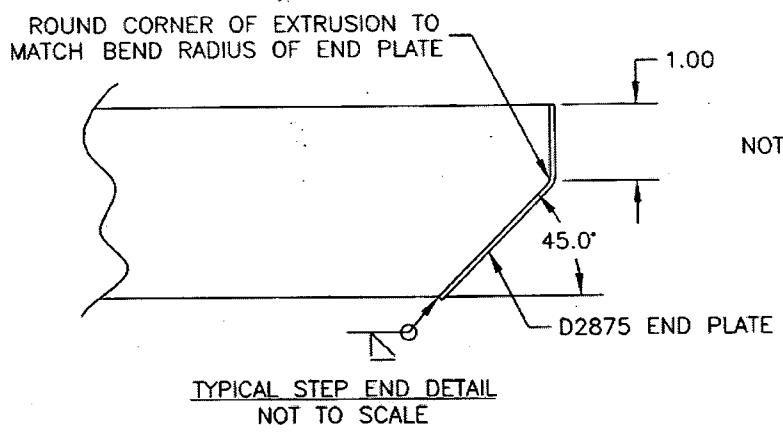
DART

QA CONTROL

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO. D2812	SHEET 1 OF 1
DATE	TITLE	STEP WELDMENT	SCALE
00.11.03			NIS
A	00.11.03	NEW ISSUE	

RELEASED
00-11-20

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2812-041 LH STEP ASSEMBLY (SHOWN)
D2812-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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L Lacelle

From: Peggy McDonald [peggy@darths.com]
Sent: August 20, 2007 9:24 AM
To: 'L Lacelle'
Cc: 'Bill Beckett'; 'Brigitte Golden'
Subject: FW: W8485-085389 - AC Steps

Use the GREEN you used before on these steps for DND.

Peggy

From: Kim Horn [mailto:Kim.Horn@pwgsc.gc.ca]
Sent: August 20, 2007 9:04 AM
To: peggy@darths.com
Subject: W8485-085389 - AC Steps

Good morning Peggy,

I got a response from the Tech and he has advised that they require Olive Drab color. Please proceed with the order in Olive Drab.

If you require additional information, please don't hesitate to contact me.

Thanks,

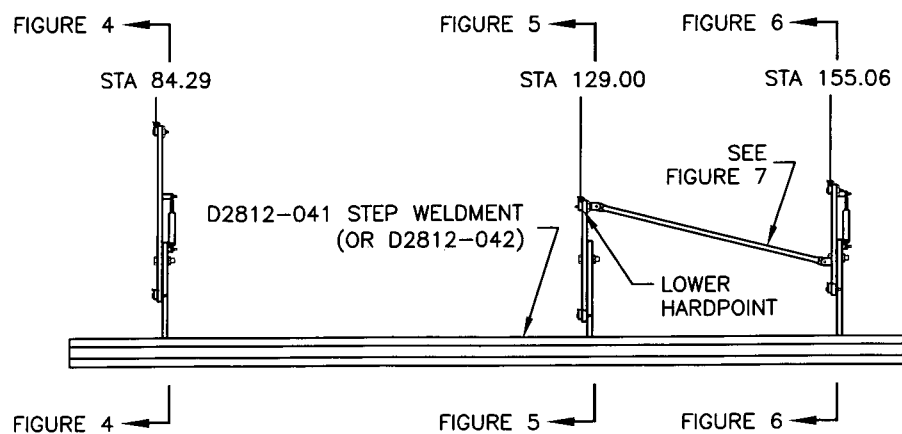
Kim Horn
PR Team Leader
BYE-100, LAMS
Phone (519) 956-0271
Fax (519) 956-4717

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Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

D412-630-011 HELI-ACCESS-STEP™ LH, HEAVY DUTY FOLDING (SHOWN)
D412-630-012 HELI-ACCESS-STEP™ RH, HEAVY DUTY FOLDING (OPPOSITE)



D412-630-013 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-014 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)

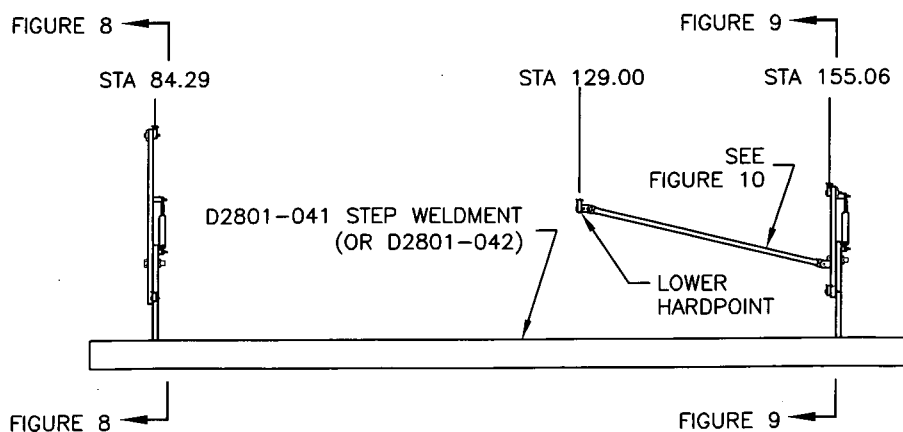
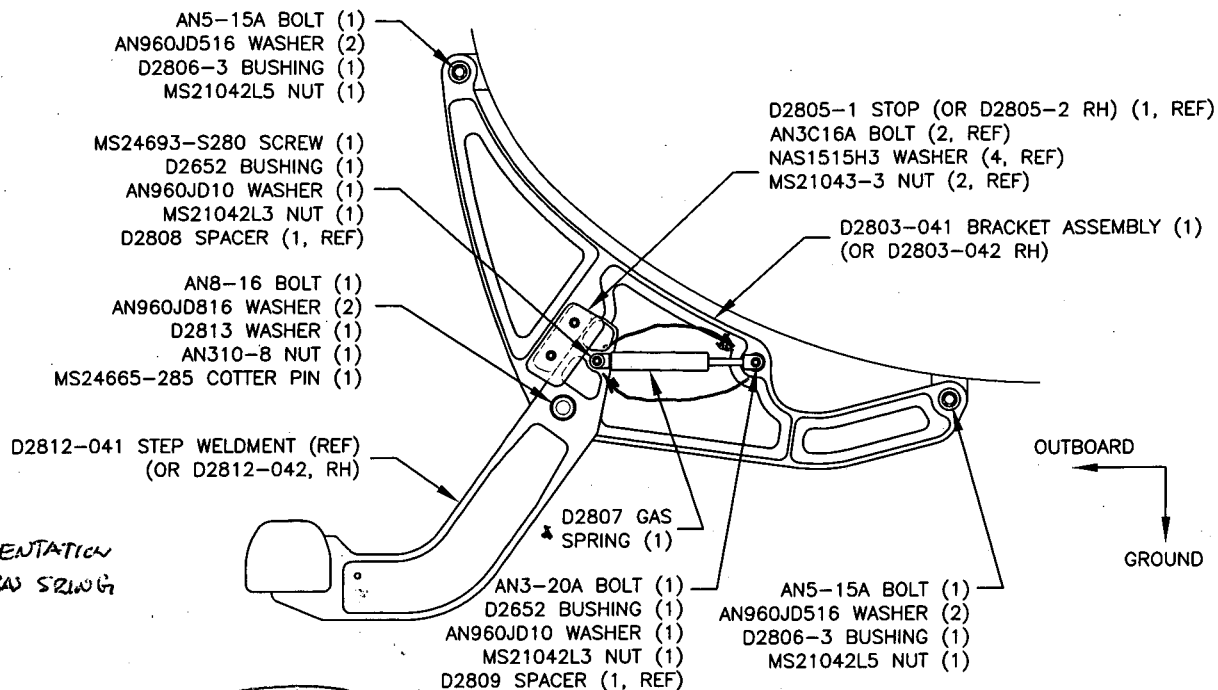
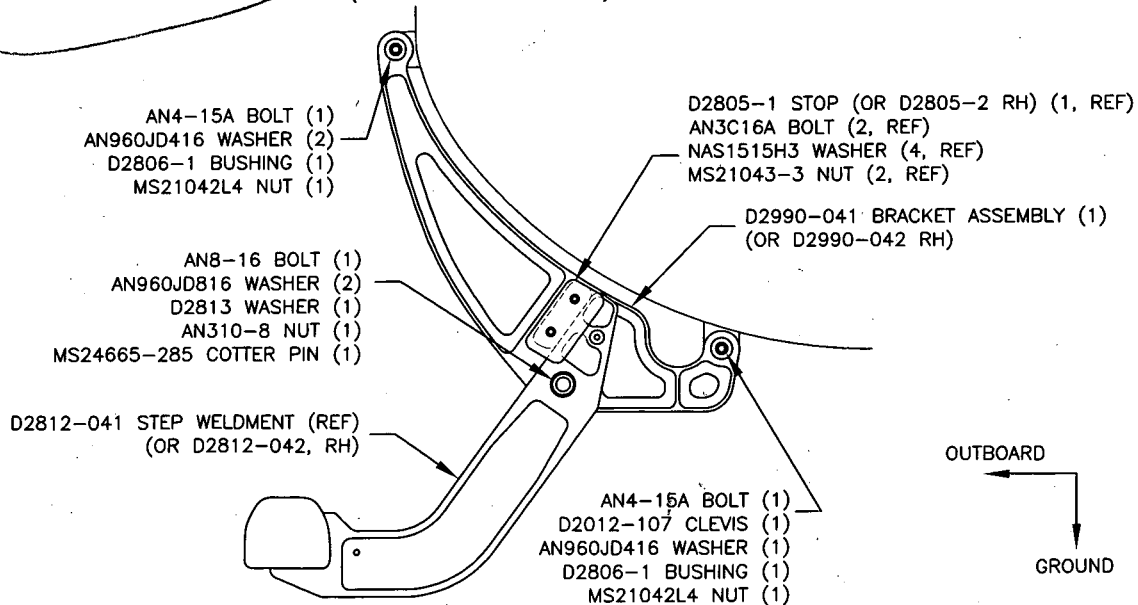


FIGURE 2 – D412-630 Heli-Access-Step™ Installations

D412-630-011/-012 Heli-Access-Step™ Installation**FIGURE 4 – STA 84.29 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)**

07.06.23
* REVERSE ORIENTATION
OF D2807 GAS SPRING

**FIGURE 5 – STA 129.00 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **K**
Date: 06.10.05

FIGURE 6 – STA 155.06 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)

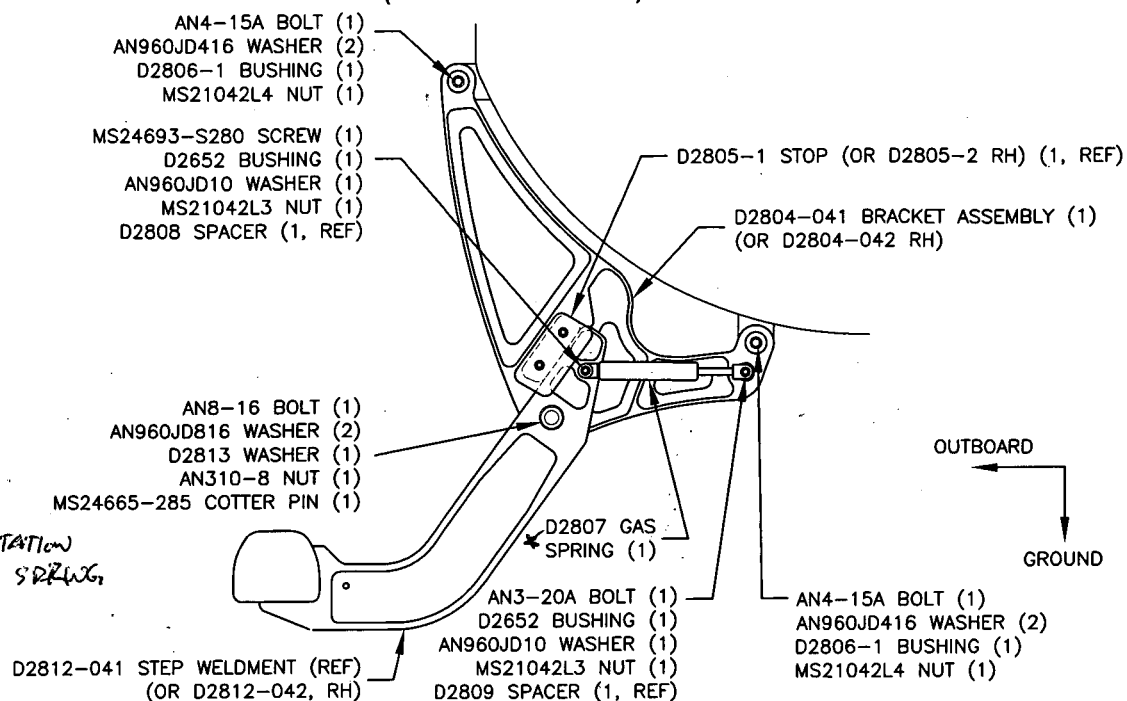
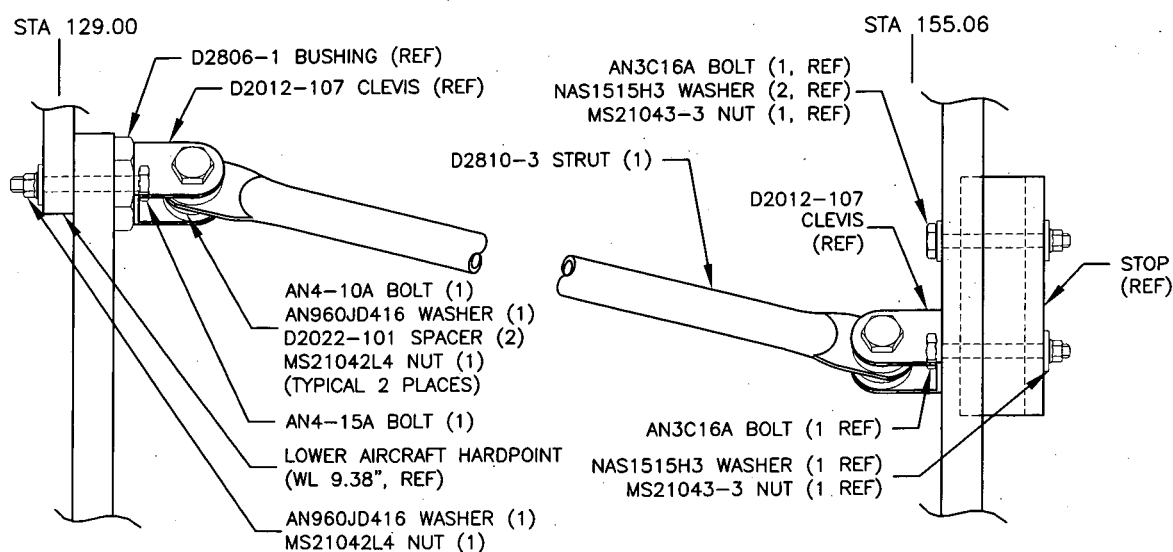


FIGURE 7 – Strut Detail for D412-630-011/-012 Heli-Access-Step™ Installation
(NOT TO SCALE)



Tuesday, 7/17/2007 1:57:59 PM

User: Kim Johnston

Process Sheet

35

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS STEP RH HEAVY DUTY
Job Number : 33575	Part Number : D412630012
Estimate Number : 12947	Drawing Number : D2812 REV A
P.O. Number :	Project Number : N/A
This Issue : 7/17/2007 S.O. No. :	Drawing Revision : A
Prsht Rev. : NC	Material : 8/30/2007
First Issue : / / Type : SMALL /MED FAB	Due Date : 8/30/2007
Previous Run :	Qty: 7 Um: Each
Written By : <u>07.07.17</u>	No LATER!
Checked & Approved By : <u>07.07.17</u>	
Comment : Est Rev: Now in Coss 07-07-17 JLM	Verified By: EC

Additional Product

Job Number :

Seq. #:

Machine Or Operation:

Description :

0 DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-630-012

CHG 005

0 D2622120C

Extrusion

Comment: Qty: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)

Extrusion

Batch: 332058

a.m

07.08.09

(2)

3.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut Extrusion as per D2812.

a.m 07.08.09

(7)

2-Bevel End and Deburr.

07.08.09

4.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

07/08/10

(17)

5.0

D2795042

Arm RH

Comment: Qty: 3.0000 Each(s)/Unit Total: 21.0000 Each(s)

Arm LH

Batch: 333588

07.08.10

Date: Tuesday, 7/17/2007 1:57:59 PM
 User: Kim Johnston

Process Sheet

35

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS STEP RH HEAVY DUTY
Job Number : 33575	
Estimate Number : 12947	
P.O. Number :	Part Number : D412630012
This Issue : 7/17/2007 S.O. No. :	Drawing Number : D2812 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 8/30/2007 Qty: 7 Um: Each
Checked & Approved By : <u>[Signature]</u>	Verified By: EC
Comment : Est Rev: Now in Coss 07-07-17 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-630-012

CHG 005

07.07.31

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Extrusion

Batch: _____

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut Extrusion as per D2812.

2-Bevel End and Deburr.

REFERENCE ONLY

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	D2795042	Arm RH
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 21.0000 Each(s)

Arm LH

Batch: _____